



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4016-3
Job Sheet 167089



Part No: D4016-3

Job Qty: 100 ea

Part Name: Hinge Half, Lid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 10/31/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea		10/27/17	0.00	0.00	Start Up Machining	
100	Bandsaw	100 pcs		10/27/17	0.00	3.87	Bandsaw1	
110	CNC Vertical Machining	100 pcs		10/31/17	0.09	36.76	HAAS 1	E.M. 12/1/17
130	QC	100 pcs		10/31/17	0.00	0.00	QC8	B.P. 17-11-18
160	Packaging	100 pcs		10/31/17	0.00	0.00	Packaging3	17-11-18
170	QC21-SA	100 Ea		10/31/17	0.00	0.00	QC21	

Part Op 100 - CUT BLANK as per folio

Descriptions: 110 - MACHINE AS PER FOLIO FA874 AND DWG

160 - LOCATION: WA004

DAS
21
9-89

NOV 20 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304B1.000X1.000	8	12	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Lid	0.880Inches ± 0.030	0.910 0.850		
2	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100		
3	Hinge Half, Lid	0.250Inches ± 0.010	0.260 0.240		
4	Hinge Half, Lid	0.030Inches ± 0.030	0.060 0.000	Radius	
5	Hinge Half, Lid	0.130Inches ± 0.030	0.160 0.100		
6	Hinge Half, Lid	0.500Inches ± 0.030	0.530 0.470		
7	Hinge Half, Lid	0.630Inches ± 0.030	0.660 0.600		
8	Hinge Half, Lid	0.563Inches ± 0.010	0.573 0.553		
9	Hinge Half, Lid	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	

DQA: _____ Date: _____

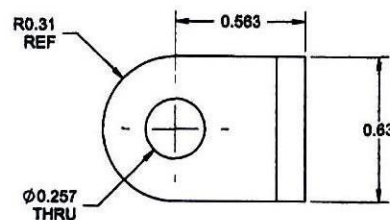
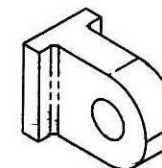
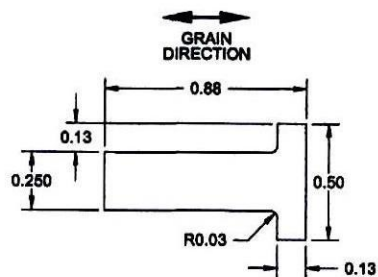
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date : _____ Step # _____	 S010799 Hinge Half, Lid Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																								
Description Work Order _____		MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
PART NO: D4016-3 Revision: Operation: Start up Operation Change No:		Mfg Date: 11/16/17 Job No: 167089																																																							
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OTHER : _____																																																									



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4118)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2017-03-22

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4016	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET HINGE	NTS
DATE	17.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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